

Date: Wednesday, 15/04/2009 10:11:08 AM
 User: Melanie Fauteux

Process Sheet

RUSH

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 47219		
Estimate Number	: 13852		
P.O. Number	:	Part Number	: D35704
This Issue	: 15/04/2009 S.O. No. :	Drawing Number	: D3570 REV D PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D PRELIM
Previous Run	:	Material	:
Written By	:	Due Date	: 17/04/2009 Qty: 1 Um: Each
Checked & Approved By	: MF 09-04-15		
Comment	: Est Rev:A New Issue 09.04.14 EC verified by:DD		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0746 sf(s)/Unit Total : 0.0746 sf(s)
 6061-T6 .125 Sheet
 Batch: 110062 189-4-16

Grain must be Along 4.63**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3570
 Dwg Rev: PRE
 Prog Rev: Lim 189-4-16

2-Deburr if necessary 189-4-16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ENGINEERING
 APPROVAL
 09-04-16 (3)
 ASS 09.04.17

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Form as per Dwg D3570 Using DT8945

FB 09-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/04/2009 10:11:08 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 47219

Part Number: D35704

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut excess material per Dwg D3570.

3-Drill as per Dwg D3570 Using Dt8946

6.0

QC5

INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

AS 09.04.17

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

CMO/PA

X3

09/04/17

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 109648

START TIME:

10:00am

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:30am

gip

09-04-17

X3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09.04.17

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location:

ST 245A

x2

1 x P.O. #8437

09/04/17 X3

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/17

Job Completion



0209/04/17

POSITIVE RECALL

EFFECTIVE

09.04.15

AUTH

U

RELEASED

AS

DATE 09.04.17

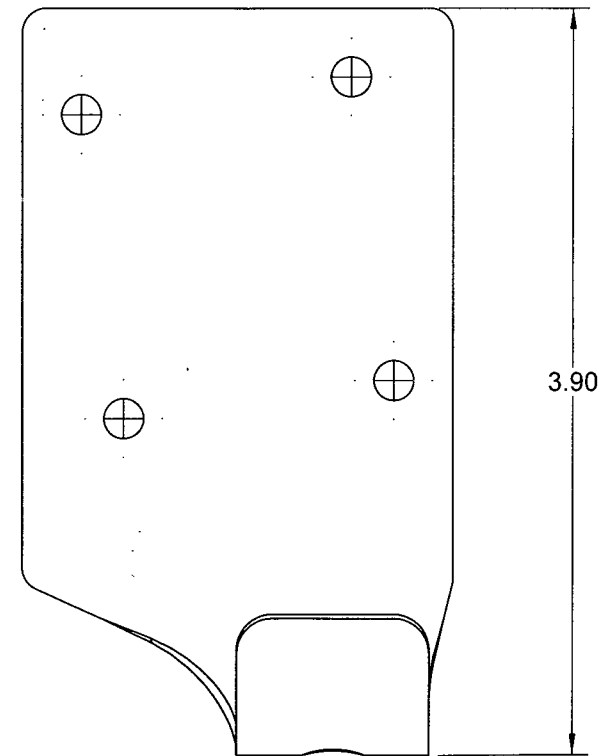
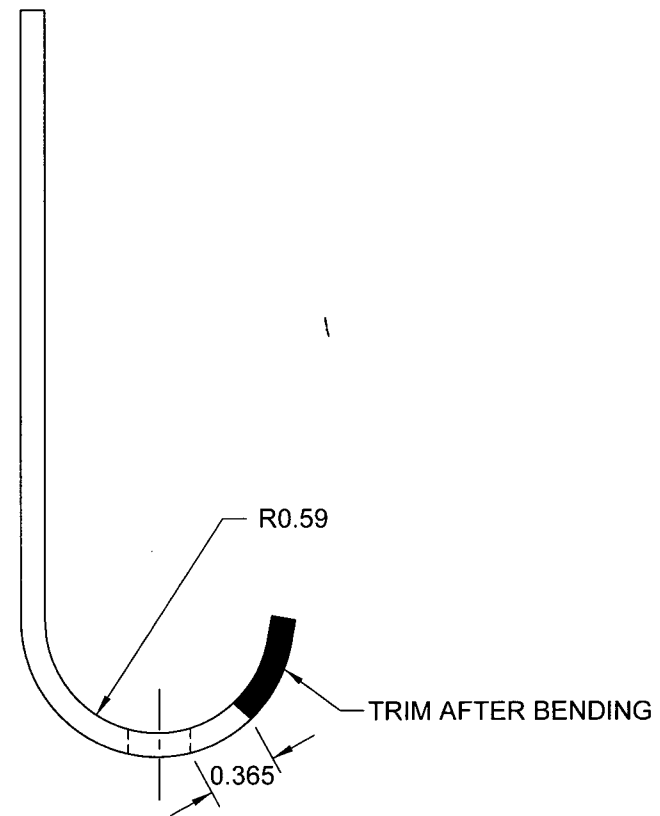
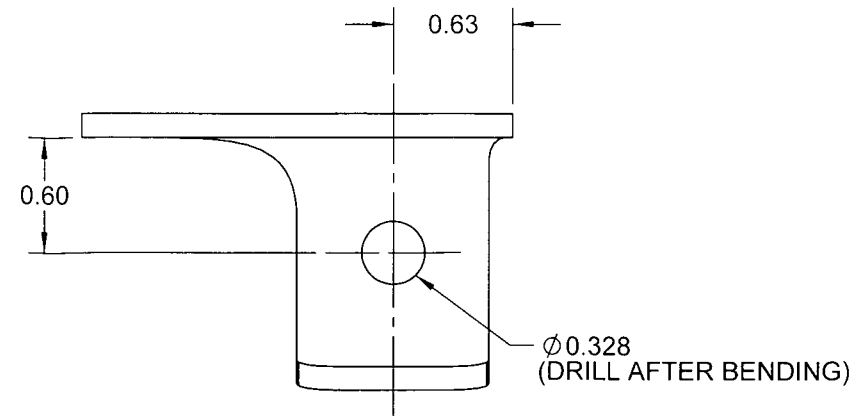
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

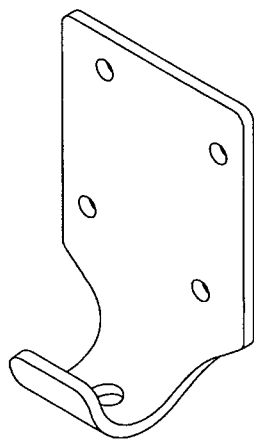


D3570-4 BRACKET
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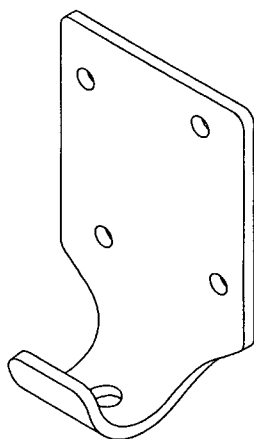
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ISSUE**
AJS 08.04.14

47219

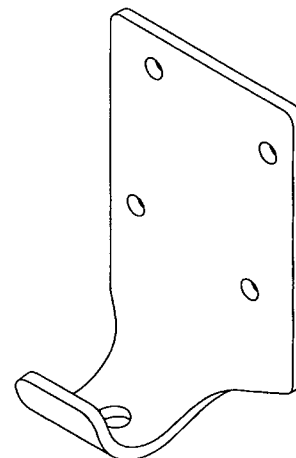
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CHECKED		DRAWING NO.	REV. D
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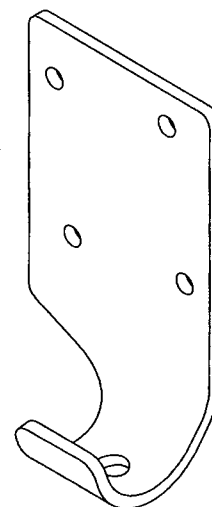
D3570-1 BRACKET



D3570-2 BRACKET



D3570-3 BRACKET



D3570-4 BRACKET

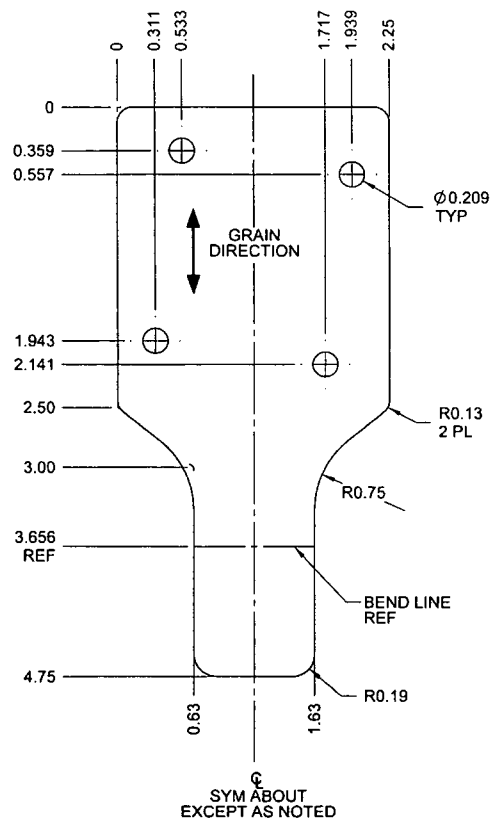
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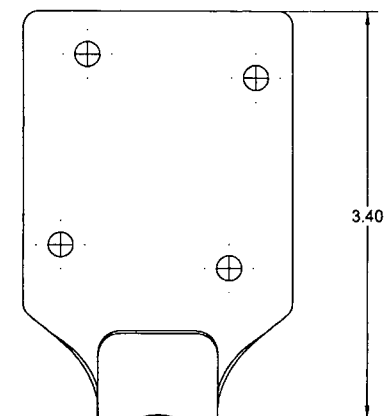
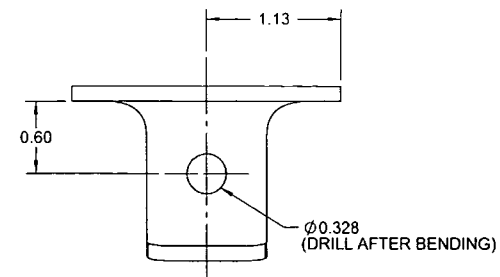
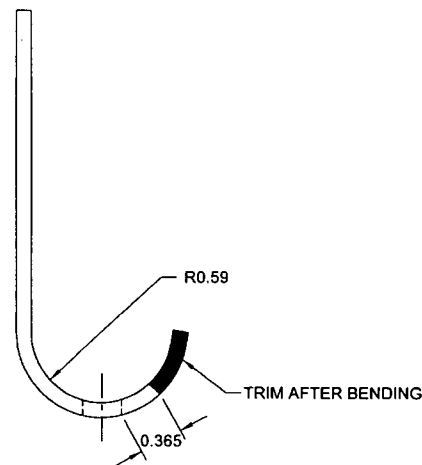
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANOTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3570-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs EACH

D	ADDED -3 & -4 FOR USE ON 214B/B1. SEE PAR 09-014.	AJS	09.04.01
C	UPDATE DIMS FOR CLARITY	LE	07.06.01
B	CHANGE BEND RAD TO 0.60 FROM 0.50	LE	07.04.16
A	NEW ISSUE	LE	07.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD	
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D3570-1F FLAT PATTERN

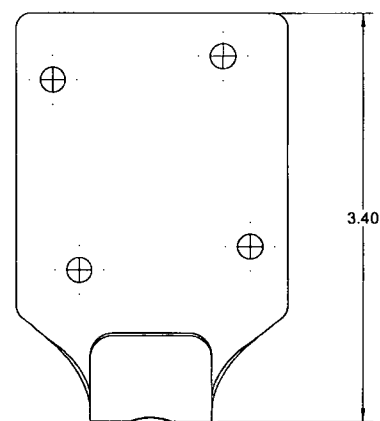
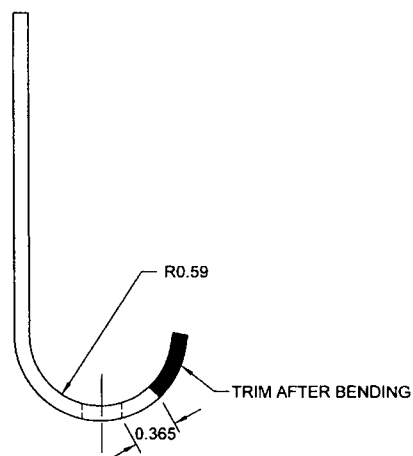
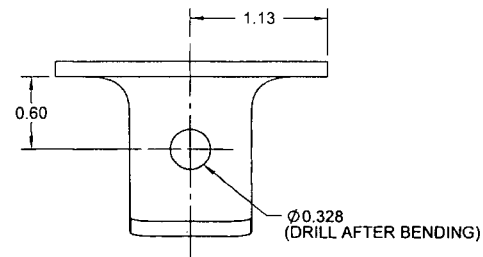


D3570-1 BRACKET
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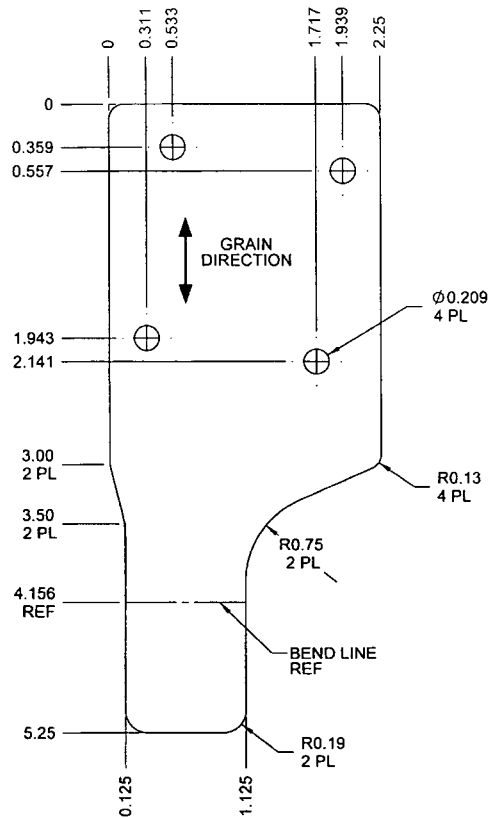


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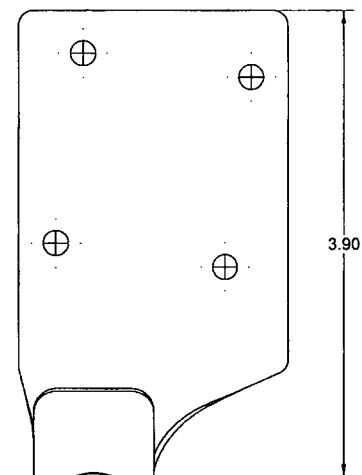
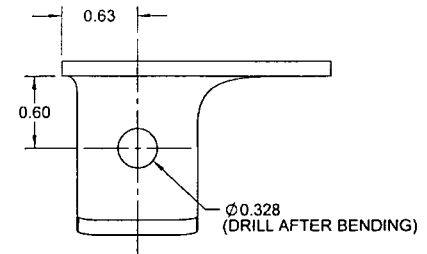
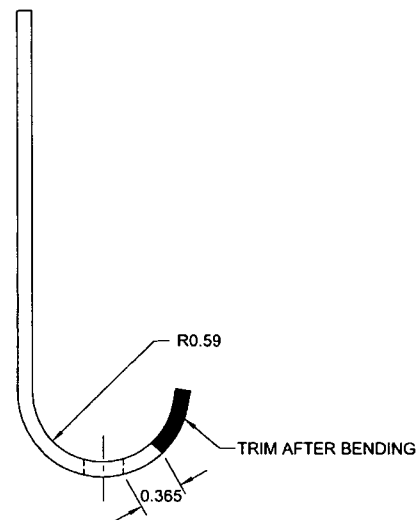
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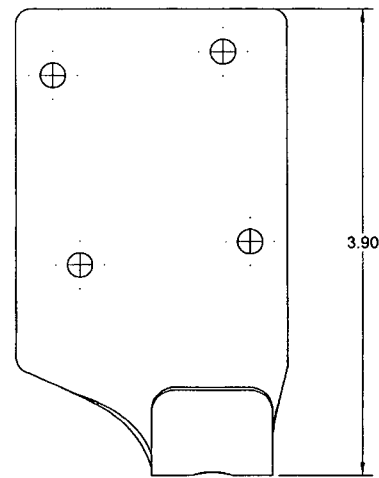
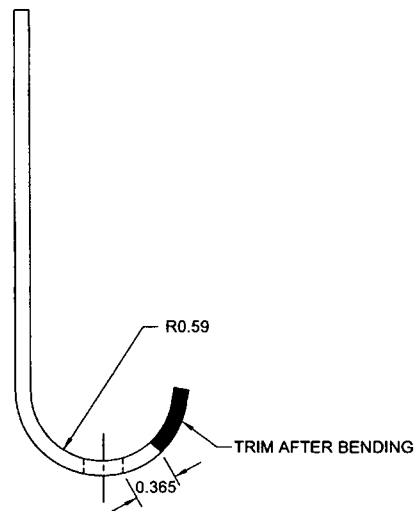
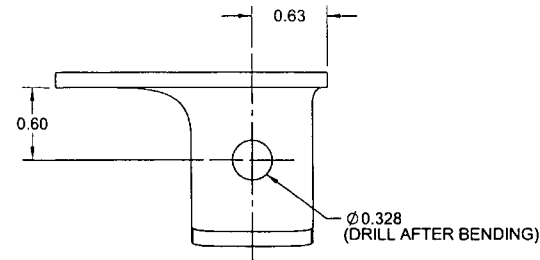


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